

Work Order ID 56647

March 3, 2010 1:11:43 PM



Page 1

Item ID: D3436-044

Accept



Setup Start



Revision ID:

Item Name: Step RH

Stop



Start Date: 03/03/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 08/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

RL

Date: *10-3-03*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3436

Rev A

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

Weld bushings D3436-5 and clamp D3436-1 using welding Jig DT8772 and

Dwg D3436 Dwg Rev: *A*

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ N/A ☐ 4130 Welding Rod ☐

Weld right step D3436-4 using welding Jig DT8773 and Dwg D3436 Dwg Rev:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ N/A ☐ 4130 Welding Rod ☐ *100075*

Weld cap D3436-7 as per Dwg D3436 Dwg Rev:

Qty ☐ Part Number ☐ Description ☐ Batch

A/R ☐ N/A ☐ 4130 Welding Rod ☐

FL 10-6-17

(X4)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 Bandsaw Jeaspa Bandsaw	BAND SAW Memo 1-Slit part D3436-041 on bandsaw as per Dwg D3436 2- deburr	0.00 0.00							<u>10-6-21</u> <u>X4</u>
120 QC Quality Control	QC9- Inspect visual per QSI004- Fusion Welds Memo	0.00 0.00							<u>PD 10.06.21</u>
130 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							<u>8/6/6/21</u> <u>X4</u> <u>17</u>

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Page 4

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Required Date: 08/03/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160



QC

Quality Control

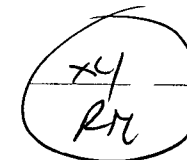
QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

5/06/30



170



Packaging

Packaging

Identify as per dwg & Stock Location: 198A

0.00

Memo

0.00

10/06/30 (4)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/30

MF
10-6-30

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56647

Parent Item: D3436-044

Parent Item Name: Step RH

Comments: IPP A ☐ 05.05.11 ☐ New Issue ☐ KJ/JLM ☐



Start Date: 03/03/2010

Required Date: 08/03/2010

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3436-5		Manufactured	No			100	Each	30.0000	16.0000			
												
Bushing												

Warehouse Loc Qty Loc Code
Location



Main Warehouse

WA

30

55727

30

D3436-7		Manufactured	No			100	Each	5.0000	4.0000			
												
Cap												

Warehouse Loc Qty Loc Code
Location



Main Warehouse

ST

5

42323

5

D3436-9		Manufactured	No			100	Each	10.0000	8.0000			
												
Pad												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST56

10

55734

10

B 56836 X1

EL 10-6-17

16

EL 10-6-17

3

EL 10/06/30

8

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

March 3, 2010 1:11:48 PM

Page 2

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Parent Item Name: Step RH


Comments: IPP A ☐ 05.05.11 ☐ New Issue ☐ KJ/JLM ☐

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Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3436-4  Right Step		Manufactured	No			100	Each	8.0000	4.0000			



2 10-6-17

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

8

46591

2

51786

6

2

2

D3436-1



Clamp

Manufactured No

155

Each

57.0000

4.0000



2 10-6-17

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA

57

17679

57

4

March 3, 2010 1:11:48 PM

Shop Packet Print

Page 2

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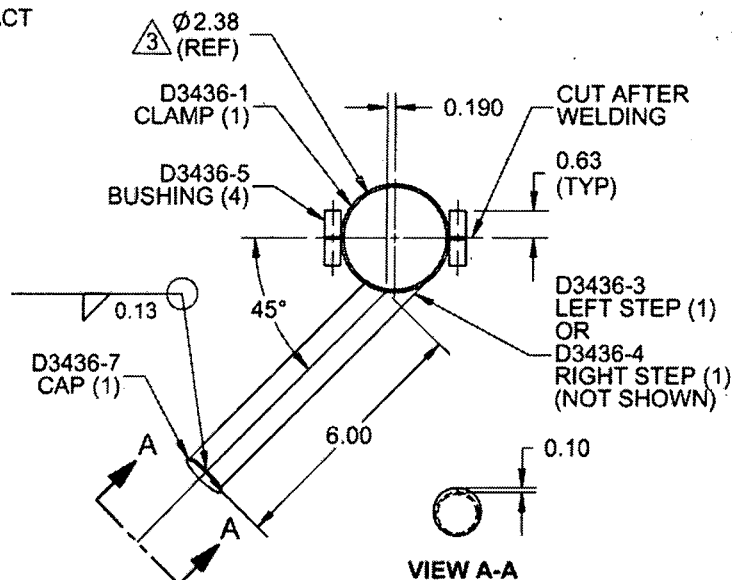
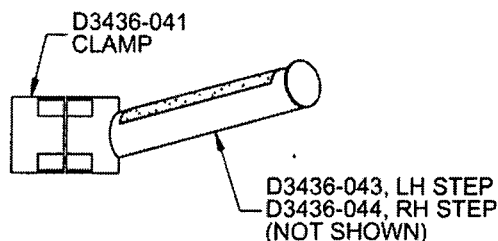
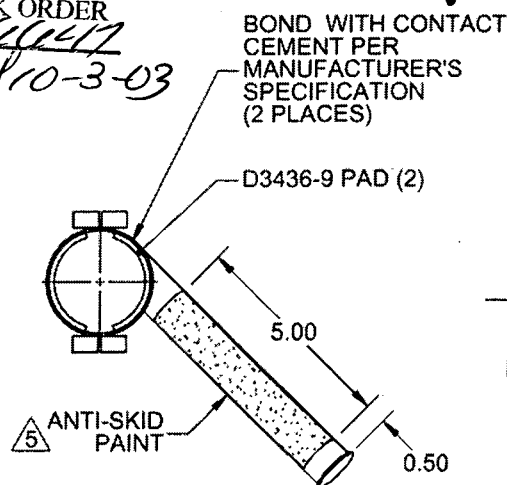
UNCONTROLLED COPY
RETURN TO
ENGINEERING

DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	

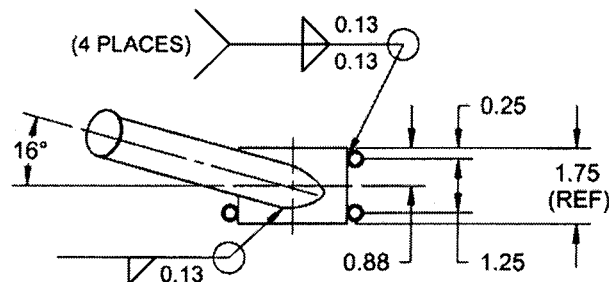
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO 540417
BX10-3-03



VIEW A-A



WELDING

NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

RELEASED

05.05.27 [Signature]

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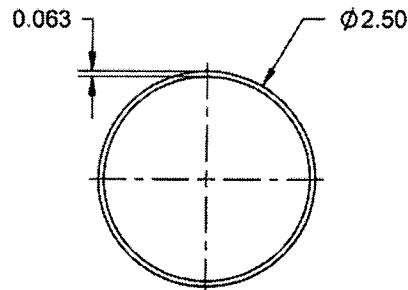
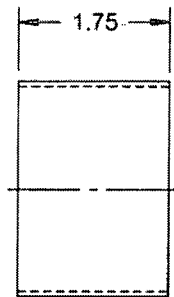
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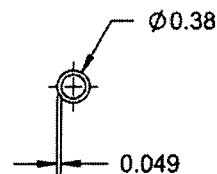
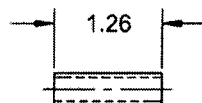
DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

W/O 56647



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

RELEASED

05-05-27 H

D3436-1/-5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

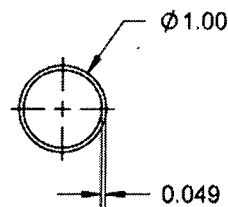
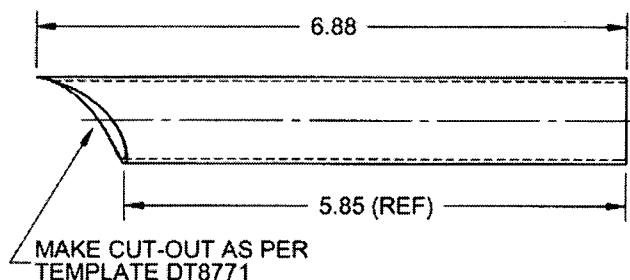
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO: D3436	REV. A SHEET 3 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2

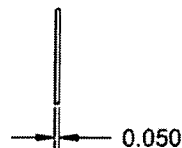
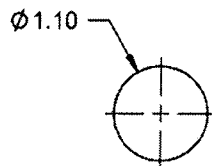
W/O Step 4?



D3436-3 LEFT STEP

(D3436-4 RIGHT STEP - OPPOSITE, NOT SHOWN)

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T1000W049)



D3436-7 CAP

- 2) MATERIAL: AISI 4130N STEEL SHEET PER MIL-S-18729, AMS6350 OR AMS 6351 (REF. DART SPEC. M4130N-S050)

RELEASED

05-05-27 *[Signature]*

D3436-3/-7, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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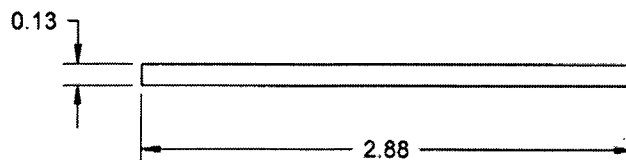
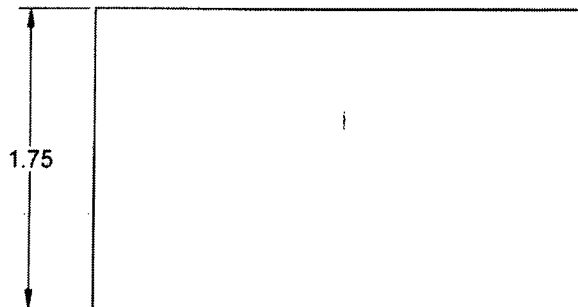
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DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1

celo 5/6/47



RELEASED

05.05.27 *[Signature]*

D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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